

Work Order ID 117118

117118

Page 1

April-24-14 9:52:29 AM

Item ID: D2732

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Rubber Extrusion

Stop *NS2*

Start Date: 4/23/14 Start Qty: 100.00

~~1000~~
~~*100*~~

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 100.00

~~*100*~~

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-29 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2732	Rev B1
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100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 24012 Seal as per dwg D2732 Possible Supplier: Accurate
 rubber P/N 110750003
 Material release note required

CL 14/04/30 1000

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

1000X SPL4-6-2

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

Check dims to dwg

SHP
4/6/3

1000

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 8 470 0.00

130

Packaging

Memo

0.00

Packaging

1000x sp 14-6-3

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-06-03
MLJ 14-06-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

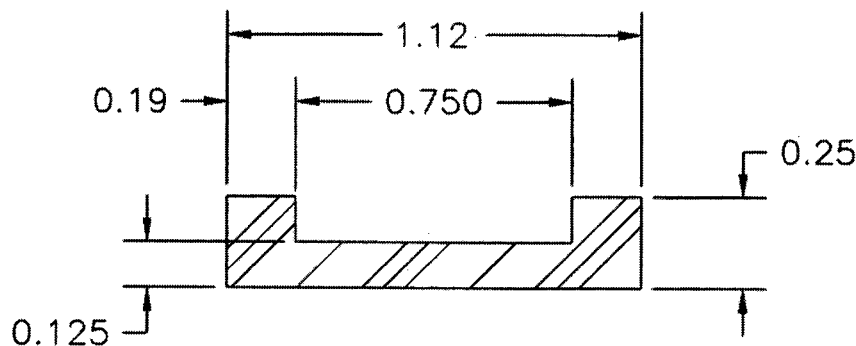
FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2732	REV. B SHEET 1 OF 1
DATE 98.03.05		TITLE RUBBER EXTRUSION	SCALE 2:1
A	97.12.04	NEW ISSUE	
B	98.03.05	BLACK WAS WHITE	
B1	<i># CP</i> 02.05.23	ADD POSSIBLE SUPPLIER	

RELEASED
98/03/06 KE



D2732-050 RUBBER CUSHION

LENGTH

EG: 3.5 LONG: D2732-035
10 LONG: D2732-100

117118 M5
14129
62-ho-h1

MATERIAL: NEOPRENE BLACK 50 DUROMETER
NOTE: ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED



POSSIBLE SUPPLIER: ACCURATE RUBBER P/N 110750003



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24012**

Purchase Order Date 4/30/2014

PO Print Date 5/1/2014

Page Number 1 of 2

Order From :

VC-ACR001

ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 604 274 9955

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

FAKED

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Pri
1	110750003 AS PER DWG D2732 REV. B B117118	Rubber Extrusion	5/23/2014 Yes 5/23/2014		1,000.00 Each	\$3.00	\$3,000.00
						Line Total:	\$3,000.00
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A015 shelf life controlled material 60% A016 personnel qualification A017 raw material identification A026 certification of material conformance A041 Quality management system A043 retention of quality documents	PROCUREMENT QUALITYCLAUSES	5/23/2014 No 5/23/2014		1.00	\$0.00	\$0.00

SP14-6-2.

Note:

5/1/2014



www.acrgroup.ca

12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP

CUSTOMER COPY

PACKING SLIP 00150439

CUSTOMER NO. 10750

PST#

S
O
L
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T
O

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

S
H
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P
T
O

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

DATE		SHIP VIA		TERMS	
05/27/14		DAY & ROSS		ACR GROUP INC. NET 30 DAYS	
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON	
P024012		05/01/14		00150439 ROB	
QUANTITY		ITEM NUMBER		DESCRIPTION	
ORDERED	SHIPPED	B.O.			
1000	1000	-	110750003	EXTRUSION, DIE # 621 ,A106 AS/DWG.	FT
<p>5014-6-2</p> <p>190#</p> <p>SUBTOTAL HST</p>				<p>TOTAL AMOUNT</p>	

Quality Rubber Products To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Molded and Extruded Rubber Products, Cast Polyurethane Specialties



12771 No. 5 Road
Richmond, B.C. V7A 4E9
Canada
Telephone : (604) 274-9955
Fax : (604) 274-1013

CERTIFICATE OF COMPLIANCE

Date : 2014-05-26

Customer : Dart Aerospace LTD

Customer P.O. # : PO24012

Specification: N/A

Customer Ref.# / Stock # : N/A

Serial # : N/A

ACR W.O. # : 15043901

Item # : 110750003

Item Description: Extrusion, Die # 621

ACR Compound : A - 106

Date Shipped: May 26, 2014

Carrier: _____

B / L : _____

This Certifies that to the best of our knowledge the material delivered under this contract is in accordance with the terms of the contract, and with ACR Group quality standards.

Michael Reilander

(ACR GROUP INC. REPRESENTATIVE)